

Work Order ID 48495

June 26, 2009 12:45:22 PM



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Item ID: D3766-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rear Rail

Start Date: 15/07/2009 Start Qty: 10.00



Required Date: 03/08/2009 Req'd Qty: 10.00



Reference:

Approvals: Process Plan: *MP*Date: *05-01-04* Tooling:

Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Date:

Date:

Run Start



Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**
Draw Nbr
Revision Nbr

D3766

Rev B

100



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab *✓*

I-cut tube to length as per dwg D37661 :2-drill holes thru to finish size as per dwg D3766 using DT9413 ,Drill holes labelled #3. 3- deburr

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

10

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Page 2

Item ID: D3766-3**Accept****Setup** **Start****Revision ID:** B**Stop****Item Name:** Rear Rail**Start Date:** 15/07/2009 **Start Qty:** 10.00**Cust Item ID:****Required Date:** 03/08/2009 **Req'd Qty:** 10.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run** **Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130



QC3- Inspect Part Finish

0.00

QC

**Memo**

0.00

Quality Control

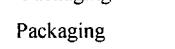
140



Identify as per dwg & Stock Location: _____

0.00

Packaging

**Memo**

0.00

Packaging

150



QC21- Final Inspection - Work Order Release

0.00

QC

**Memo**

0.00

Quality Control

Picklist Print

Page 1

June 26, 2009 12:45:21 PM

Work Order ID: 48495



Parent Item: D3766-3RevB



Parent Item Name: Rear Rail

Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	0.0000	29.3968			

6061T6 RD TUBE 1.00 X .188W



Date: Thursday, 11/06/2009 11:55:50 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REAR RAIL		
Job Number	: 48495			Part Number	: D37663	
Estimate Number	: 13494			Drawing Number	: D3766 REV B	
P.O. Number	:			Project Number	: N/A	
This Issue	11/06/2009	S.O. No.	:	Drawing Revision	: B	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 42873			Due Date	: 19/06/2009	
Written By	:			Qty:	10	
Checked & Approved By	: <u>Julie Dawson</u>			Um:	Each	
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W	
Comment: Qty.: 2.9323 f(s)/Unit Total : 29.3234 f(s) 6061T6 RD TUBE 1.00 X .188W batch:			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3766 2-drill holes thru to finish size as per dwg D3766 using DT9413 ,Drill holes labelled #3. 3- deburr			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:55:50 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR RAIL

Job Number: 48495

Part Number: D37663

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
6.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
7.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



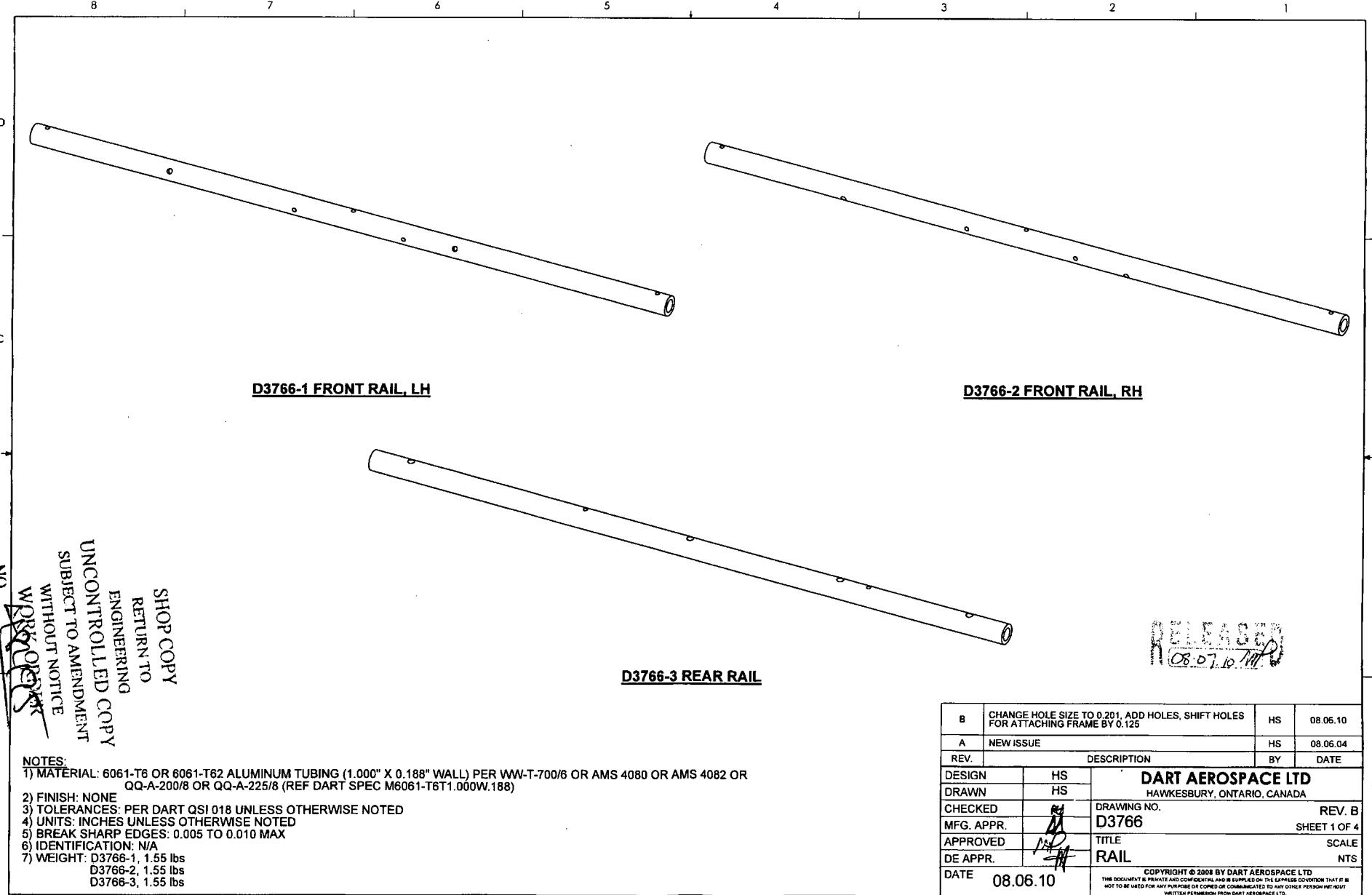
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

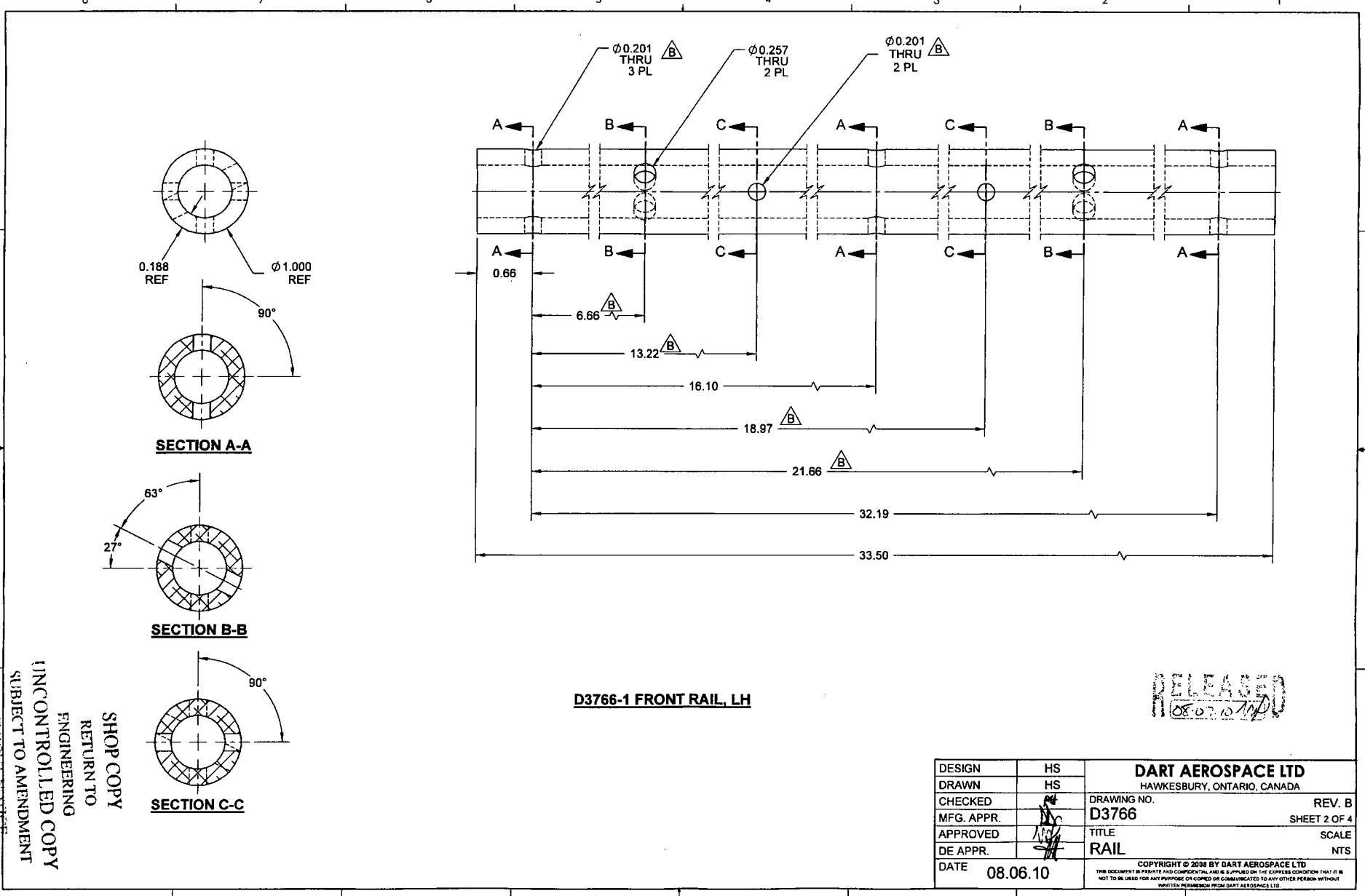
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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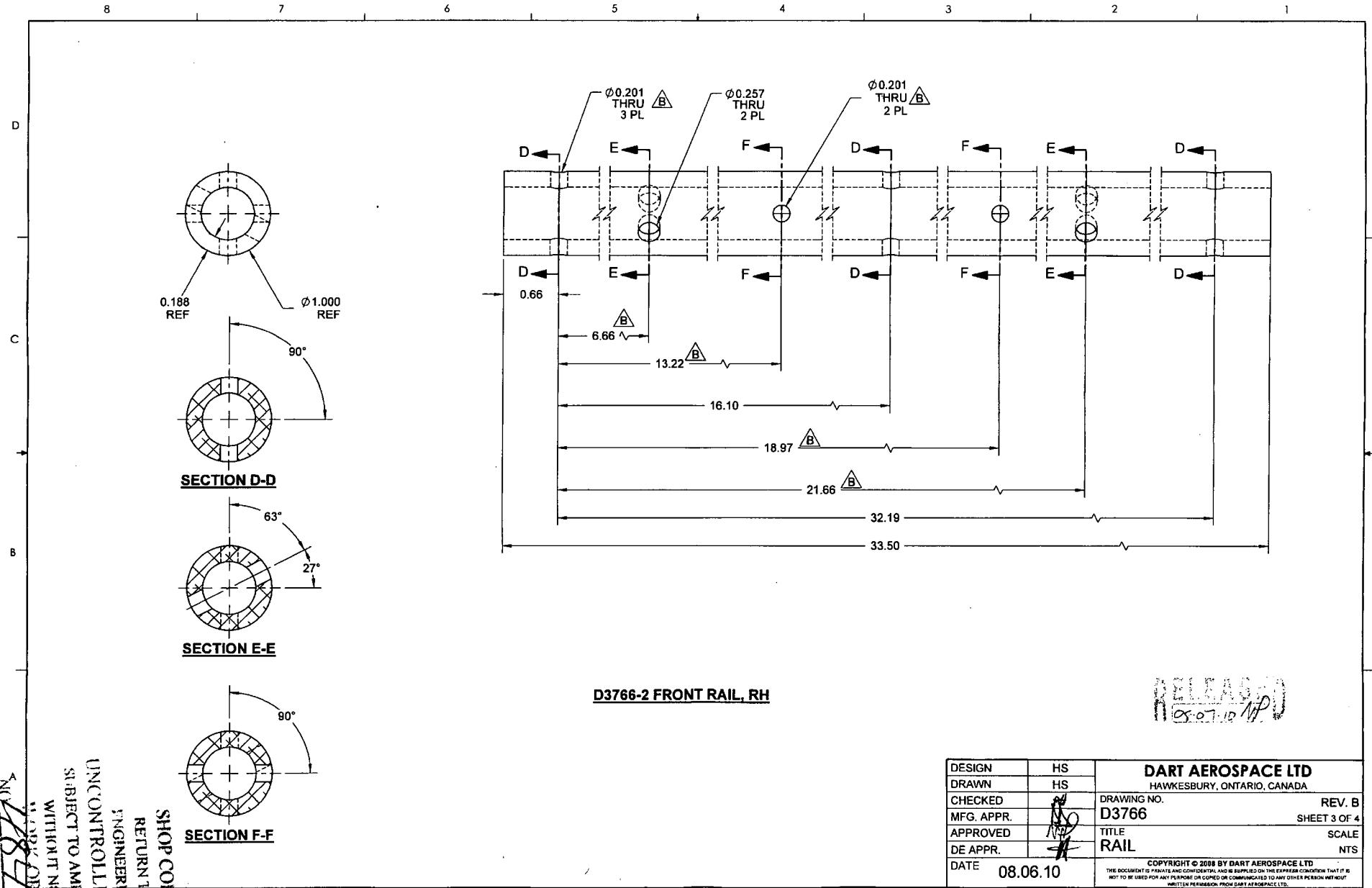
NOTE: Date & initial all entries





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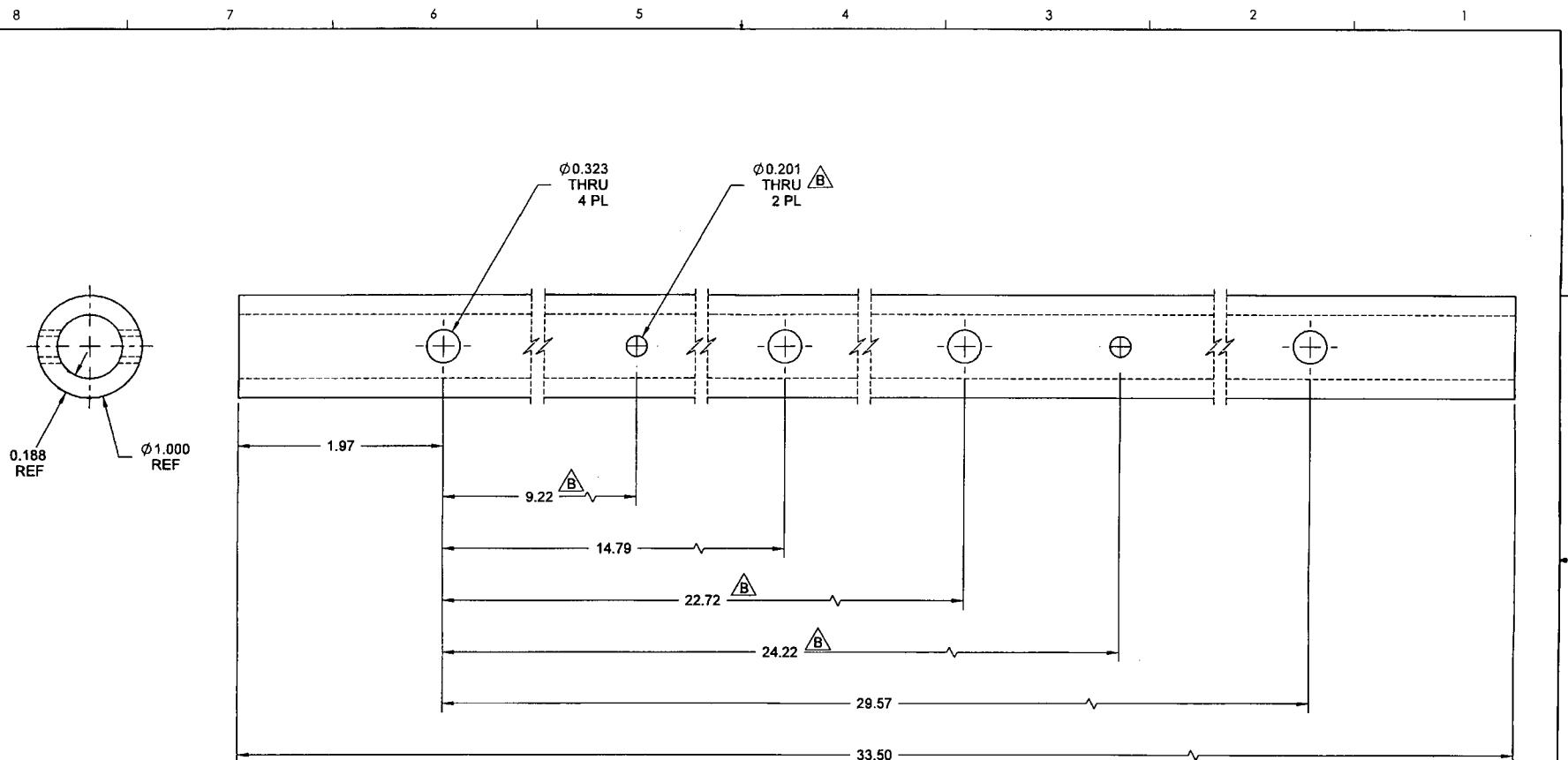
8 7 6 5 4 3 2 1 0



DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	REV. B	
MFG. APPR.	NO	DRAWING NO. D3766	
APPROVED	AP	SHEET 3 OF 4	
DE APPR.	AP	TITLE RAIL	
DATE	08.06.10	SCALE NTS	

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D3766-3 REAR RAIL

DESIGN	HS	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>AM</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AM</i>	D3766	SHEET 4 OF 4
APPROVED	<i>AM</i>	TITLE	SCALE
DE APPR.	<i>AM</i>	RAIL	NTS
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